

Work Order ID 74987

74987

Page 1

October-14-11 10:32:54 AM

Item ID: D135-751-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Installation

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11/10/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

5/12/13/27

MLJ 12-3-23

B74987

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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NS1

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Stop

NS2

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Required Date: 25/10/2011 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

DD 12-3-12
B/20

12-02-24

DD 12-3-12

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

5/12/03/12

N/G / GF 12-3-12

RD 12-3-13

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00

170

Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex

Batch: M120813

Exp Date: 12-08-13

start time: 9:05 am

end time: 12-03-14 9:00

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD

Batch: M120164

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

DP 12-3-13

2/6 12-3-13
1/12 12/03/13

CF 12-3-15

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180 QC10- Inspect visual per QSI004- ground welds

0.00

180

QC Memo

0.00

Quality Control

190

0.00

190

Skidtubes

Skidtubes Memo

0.00

Skidtubes 1-Rivet D3506-1/-3 as per Dwg D3507.

200

0.00

200

QC5- Inspect part completeness to step on W/O

QC Memo

0.00

Quality Control

8/21/15

1 10 CF 12-3-15

8/21/15

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210	Pressure Wash per QSI005 4.3	0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								

IX 4 M/L 12/03/17

220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>3:50</i>								
	OVEN TEMPERATURE: <i>300°</i>								
	FINISH TIME: <i>4:20</i>								

1 12379

230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.00							
Quality Control									

IX 4 M/L 12/03/21

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

0.00

260

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M119999
Exp Date: 12/08

3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Sccws where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: M119999
Exp Date: 12/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M110348

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 120125

1 X 4 M / 12/03/22

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Required Date: 25/10/2011 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control									
280	Pick Kit	0.00							
280									
Packaging	Memo	0.00							
Packaging									
290	QC4- 100% Inspect kits for completeness	0.00							
290									
QC	Memo	0.00							
Quality Control									

1 BL 12-3-22

12/3/22 d/c

8/26/27

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300		0.00							
300	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: <u>81</u>								
	PPP Rev: <u>B</u>								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

12/3/28
1803-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

October-14-11 10:33:02 AM

Page 1

Work Order ID: 74987

74987

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

Each

1,095.000

38

AI S7-1032-130

Insert

120181

**

38 m/12/03/21

Location

Loc Qty

Loc Code

ST281

918

118966

918

ST282

177

117717

31

118386

146

D3507-1-BENT

Manufactured

No

120

Each

3.0000

1

1

D3507-1-BENT

Skidtube Assembly EC135

**

12-3-12

Location

Loc Qty

Loc Code

LG

3

71201

1

72564

2

77441

1

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D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each

13.0000

2 2

D3504-1

Crossbolt Spacer

**

BE 12/03/14

Location

Loc Qty

Loc Code

LG

11

71130

11

LG001

2

53742

2

D3504-3 Manufactured No

170 Each

17.0000

1 1

D3504-3

Crossbolt Spacer

**

BE 12/03/14

Location

Loc Qty

Loc Code

LG001

17

53743

17

D3504-5 Manufactured No

170 Each

11.0000

2 2

D3504-5

Crossbolt Spacer

**

BE 12/03/14
27/12/26 +2

Location

Loc Qty

Loc Code

LG

11

71226

11

D3505-1 Manufactured No

170 Each

0.0000

1 1

D3505-1

Web

**

D3506-1

Manufactured No

190 Each

11.0000

4

D3506-1

Doubler

**

74733

④

CF 12-3-15

Location

Loc Qty

Loc Code

ST063

11

51789

11

October-14-11 10:33:02 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3506-3 Manufactured No

190 Each

69.0000

2

D3506-3

**

Doubler

②

CF 12-3-15

Location

Loc Qty

Loc Code

ST063

69

51790

69

MS20601-AD4W3

Purchased

No

190

Each

2,438.000

12

12

MS20601-AD4W3

**

Rivet

12

CF 12-3-15

Location

Loc Qty

Loc Code

ST321

2438

114538

2438

ALS4-1032-225

Purchased

No

260

Each

2,610.000

1

1

AI S4-1032-225

**

Insert

120671

M-L 12/03/21

Location

Loc Qty

Loc Code

ST282

2610

108696

758

110768

62

118386

860

118966

930

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

260 Each

1,987.000 31 31

AN3C4A

BOLT

120769

**

m-k 12/03/21

Location

Loc Qty

Loc Code

ST350

1987

117313

2

117688

5

117872

22

118112

16

118451

442

118706

500

118838

1000

31

AN3C5A Purchased No

260 Each

1,316.000 2 2

AN3C5A

Bolt

120423

**

m-k 12/03/21

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1309

116419

28

117343

110

117764

169

117872

2

118451

500

119127

500

2

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 74987

74987

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10

Purchased

No

260

Each

265.0000

2

2

AN526C1032R10

Screw

**

m-l 12/03/21

Location

Loc Qty

Loc Code

FP-B

91

108062 ✓

91

ST327

100

114494

100

ST328

74

110049

74

2

AN960C10L

NAS1149C0332
R

Purchased

No

260

Each

0.0000

33

33

***AN960C10L ***

washer

D2965

Manufactured

No

260

Each

41.0000

1

1

D2965

Cap, 105 Skidtube

**

120648

33 m-l 12/03/21

**

m-l 12/03/21

Location

Loc Qty

Loc Code

FP006

41

71371 ✓

41

Manufactured

No

260

Each

4.0000

1

1

D2965-3

D2965-3

Cap

**

25254

m-l 12/03/21

Location

Loc Qty

Loc Code

FP005

4

50560

1

71300

3

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:33:02 AM

Work Order ID: 74987

74987

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No

D3492-1

Plug

260 Each 158.0000 4 4

**

M-L 12/03/22

Location	Loc Qty	Loc Code
FP	158	
69531	8	
73402	70	
74444	80	

4

D3492-3 Manufactured No

D3492-3

Plug

260 Each 117.0000 4 4

**

M-L 12/03/22

Location	Loc Qty	Loc Code
FP	117	
71838	37	
74447	80	

4

D3492-7 Manufactured No

D3492-7

Plug

260 Each 14.0000 2 2

**

M-L 12/03/22

Location	Loc Qty	Loc Code
FA-A	14	
71881	14	

2

D3508-1 Manufactured No

D3508-1

Wearplate

260 Each 15.0000 1 1

**

M-L 12/03/22

Location	Loc Qty	Loc Code
FP016	15	
61020	3	
72933	12	

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 74987

74987

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-3 Manufactured No

260 Each 6.0000 1 1

D3508-3

Wearplate

76264

**

M-L 12/03/22

Location Loc Qty Loc Code

FP021 1

38527 1

FP21 5

72169 5

D3508-5 Manufactured No

260 Each 21.0000 1 1

D3508-5

Wearplate

**

M-L 12/03/22

Location Loc Qty Loc Code

FP021 21

71688 9

72416 12

D3508-7 Manufactured No

260 Each 8.0000 1 1

D3508-7

Wearplate

**

M-L 12/03/22

Location Loc Qty Loc Code

FP020 7

72932 7

FP021 1

67739 1

D3558-1 Manufactured No

260 Each 15.0000 1 1

D3558-1

Gasket

**

M-L 12/03/22

Location Loc Qty Loc Code

FP014 15

50925 3

73561 12

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

Work Order ID: 74987

74987

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-3 Manufactured No

260 Each 4.0000 1 1

D3558-3

Gasket

75179 **

M-L 12/03/22

Location	Loc Qty	Loc Code
FP014	4	
71651	1	
72170	3	

D3558-5 Manufactured No

260 Each 5.0000 1 1

D3558-5

Gasket

67485 **

M-L 12/03/22

Location	Loc Qty	Loc Code
FP014	5	
67485	5	

D3558-7 Manufactured No

260 Each 5.0000 1 1

D3558-7

Gasket

75249 **

M-L 12/03/22

Location	Loc Qty	Loc Code
FP014	5	
67162	5	

NAS1611-007 Purchased No

260 Each 276.0000 2 2

NAS1611-007

O-RING

75249 **

M-L 12/03/22

Location	Loc Qty	Loc Code
FP-A	276	
103697	276	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 74987

74987

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

260

Each

95.0000

4

4

NAS1611-010

O-RING

Location

Loc Qty

Loc Code

FP

81

117460

8

118077

1

118612

72

FP-A

14

110915

14

NAS1611-013

Purchased

No

260

Each

92.0000

4

4

NAS1611-013

O-RING

Location

Loc Qty

Loc Code

FP

55

117291

2

117887

53

FP-A

37

116582

5

118384

32

AN3C4A

Purchased

No

280

Each

1,987.000

8

8

AN3C4A

BOLT

Location

Loc Qty

Loc Code

ST350

1987

117313

2

117688

5

117872

22

118112

16

118451

442

118706

500

118838

1000

120308

**

4 M/L 12/03/22

120910

**

4 M/L 12/03/22

~~120169~~

**

~~8 M/L 12/03/22~~
M120521 SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 74987

74987

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 14/10/2011

Required Date: 25/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

280 Each 0.0000 8 8

M 120648. 88

***AN960C10I ***

washer

D3512-1

Manufactured No

280 Each 12.0000 2 2

~~*8 M 1203/00*~~

D3512-1

Wearplate

**

12/22 5 ☐

Location

Loc Qty

Loc Code

ST500

12

73955

12

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

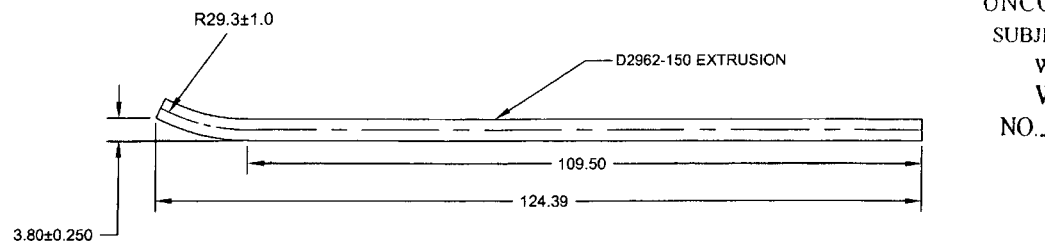
WITHOUT NOTICE
WORK ORDER
NO. 74987

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AEIS-1032-130	INSERT
1	AEIS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

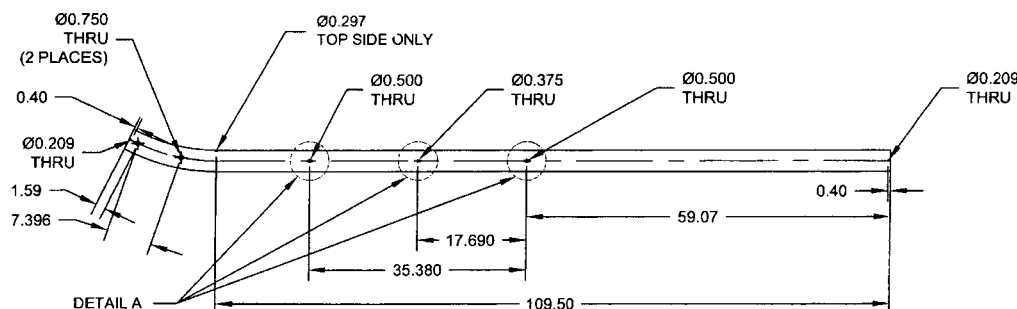
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AEIS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

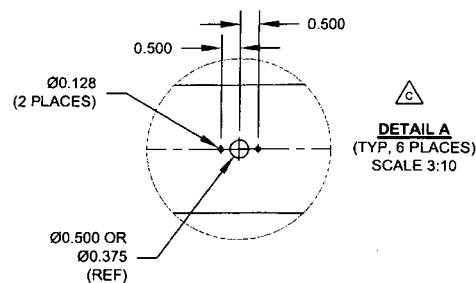
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	RC		
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	BE	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

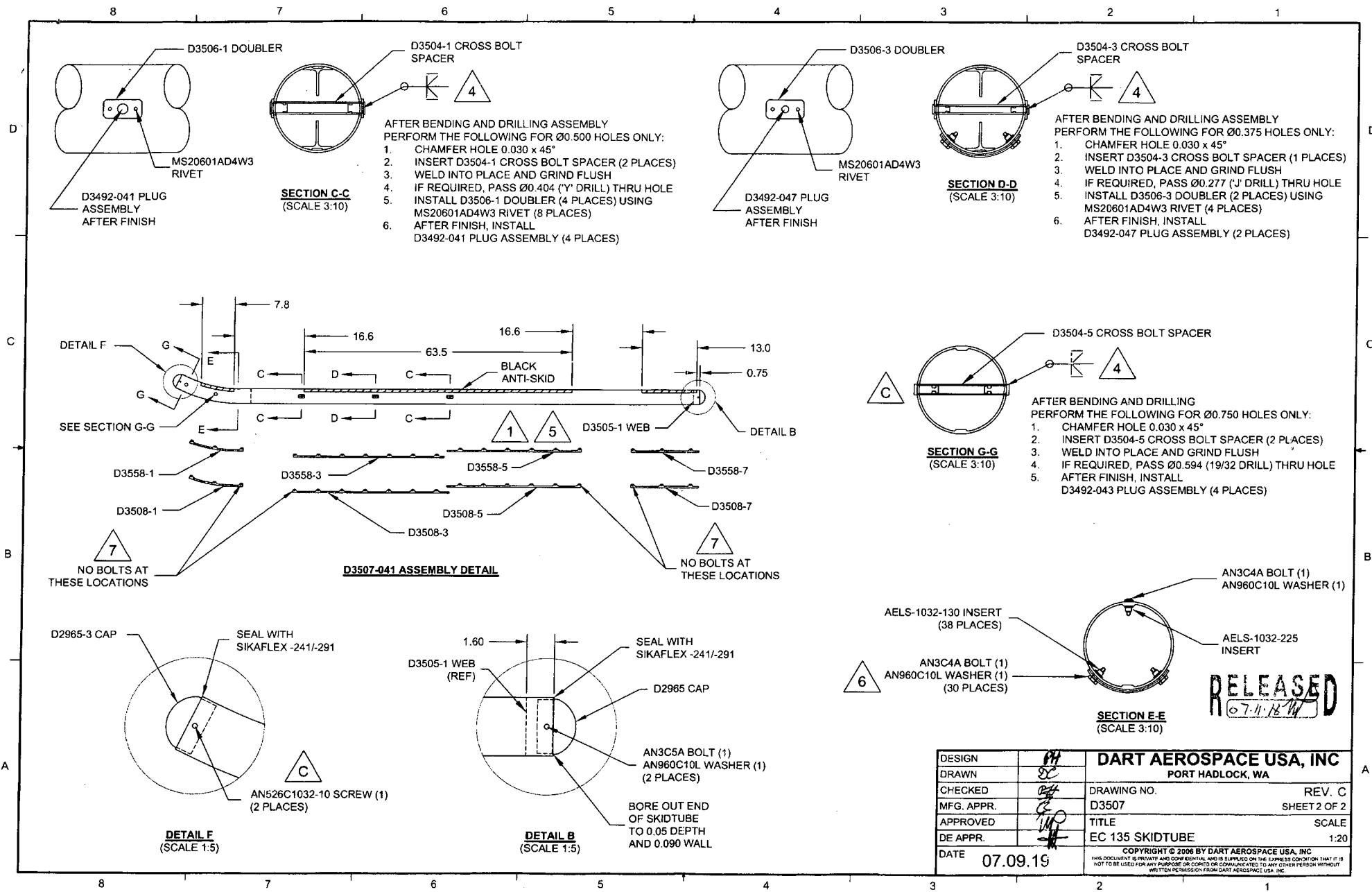
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74987



DESIGN	D3507	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	BE	D3507	SHEET 2 OF 2
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	EC 135 SKIDTUBE	1:20
DATE	07.09.19	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: C

Date: 07-09-20

NO. 257

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B666P
Part number: D135-751-011
Description: 135
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Lewis Date of Test Coupon 11-06-22
Welder Barclay Elliot Date of Test Coupon 11-06-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld